



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D412-742-043
Job Sheet 171620



Part No: D412-742-043

Job Qty: 1 ea

Part Name: Repl. Skidtube Fits LH or RH, High Gear, DART (Apical) Tri-Bag Float Comp.



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/6/18

Job Tracking No:

Due Date: 2/9/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D3391-043 REV J SHEETS 1,2 IPP Rev A 05.10.13 New Issue KJ/JLM IPP Rev 06.02.13 ECN 773 dwg
@ rev.D EC IPP Rev:C 07-05-28 As per Rev F JLM IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM IPP
Rev:E 08-09-08 ecn 08-510 DD verified by:EC IPP Rev:F 11.11.01 as per DSI9517 REV.B DD verified by:EC
IPP REV:G 16.05.02 AS PER DWG REV.J DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/8/18	0.00	0.00	Start Up Container		rel 18-2-13
110	HandFinish	1 pcs		2/9/18	0.00	3.50	HandFinish4		18 11-2-14
120	QC	1 pcs		2/9/18	0.00	0.00	QC5		38
125	DC	1 pcs		2/9/18	0.00	0.00	DC		38
130	Packaging	1 pcs		2/9/18	0.00	0.00	Packaging3-2		SmB
140	QC21-FG	1 Ea		2/9/18	0.00	0.00	QC21		21 FEB 14 2018

Part Op 110 - 1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with
Descriptions: saddle holes for proper alignment. using 7/16" "T" Pins. A/R Sikaflex-241/-291 _____ Expiry date:
2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped
with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no
sikaflex. A/R Sikaflex-241/-291 _____ Expiry date: 3-Remove "T" pins once sikaflex is dry.
4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser. A/R LPS Procyon

VERIFY FWD AND AFT SADDLE FIT DURING ASSEMBLY BY: _____ DATE: _____
125 - If D412-742-043 is a W/O on it's own, Photocopy bluefile and create labels per PPP D412-742-043 CHG007
130 - Identify and pack for shipping as per PPP D412-742-043 Location: _____ PPP Rev: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3C4A	Bolt	24 Ea (24 ea)	90-Start up Operation	5019394
AN3C6A	Bolt	4 Ea (4 ea)	90-Start up Operation	5019397
AN5C7A	Bolt	10 Ea (10 ea)	90-Start up Operation	5019411
D3391-021	Fwd Tube Assembly	1 pcs (1 ea)	90-Start up Operation	5017086
D3391-023	Mid Tube Assembly	1 Ea (1 ea)	90-Start up Operation	5022470
D3391-025	Aft Tube Assembly	1 pcs (1 ea)	90-Start up Operation	5014131
D4095-041	Wearplate Fwd	1 Ea (1 ea)	90-Start up Operation	5006063 *
D4095-043	Wearplate Aft	1 Ea (1 ea)	90-Start up Operation	5006081
D4095-045	Wearplate Center	1 Ea (1 ea)	90-Start up Operation	504102501097
NAS1149C0332R	Washer	28 Ea (28 ea)	90-Start up Operation	5019380-1
NAS1149C0532R	Washer	10 Ea (10 ea)	90-Start up Operation	5014735

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Date: _____ S041929 Repl. Skidtube Fits LH or RH, High Gear, DART (Apical) Tri - Bag Float Comp. PART NO: D412-742-043 Original Serial #: S041929 Revision: Operation: Start up Operation 02/13/18 Change No: CHG007 Job No: 171620	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th colspan="4" style="text-align: center;">AGAINST DEPARTMENT/PROCESS</th> </tr> <tr> <td style="width: 15%;">☐</td> <td style="width: 15%;">Skid-tube</td> <td style="width: 15%;">☐</td> <td style="width: 15%;">Cross tube</td> </tr> <tr> <td>☐</td> <td>Machining</td> <td>☐</td> <td>Small Fab</td> </tr> <tr> <td>☐</td> <td>Thermoforming</td> <td>☐</td> <td>Finishing</td> </tr> <tr> <td>☐</td> <td>Large Fab</td> <td>☐</td> <td>Composite</td> </tr> <tr> <td>☐</td> <td></td> <td>☐</td> <td>Water Jet</td> </tr> <tr> <td></td> <td></td> <td>☐</td> <td>Prod. Eng. Coord.</td> </tr> <tr> <td></td> <td></td> <td>☐</td> <td>Rec/Store/Packaging</td> </tr> <tr> <td></td> <td></td> <td>☐</td> <td>Supplier</td> </tr> <tr> <td></td> <td></td> <td>☐</td> <td>Engineering</td> </tr> <tr> <td></td> <td></td> <td>☐</td> <td>Quality</td> </tr> <tr> <td></td> <td></td> <td>☐</td> <td>Other</td> </tr> <tr> <td colspan="3">QTY Effective :</td> <td>MRB (QSI042) Approval</td> </tr> <tr> <td colspan="3" style="text-align: center;">Disposition</td> <td>Completed By</td> </tr> <tr> <td colspan="3" rowspan="2"></td> <td>Lead hand / Supervisor Approval Verification</td> </tr> <tr> <td>QC / QA Coordinator Approval</td> </tr> </table>	AGAINST DEPARTMENT/PROCESS				☐	Skid-tube	☐	Cross tube	☐	Machining	☐	Small Fab	☐	Thermoforming	☐	Finishing	☐	Large Fab	☐	Composite	☐		☐	Water Jet			☐	Prod. Eng. Coord.			☐	Rec/Store/Packaging			☐	Supplier			☐	Engineering			☐	Quality			☐	Other	QTY Effective :			MRB (QSI042) Approval	Disposition			Completed By				Lead hand / Supervisor Approval Verification	QC / QA Coordinator Approval
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